

**Work Order ID 77882**

December-22-11 10:10:05 AM

**\*77882\***

Page 1

Item ID: D4148-041      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
Revision ID:      Stop      **\*NS2\***  
Item Name: Crosstube Lug Assembly, Fwd  
Start Date: 22/12/2011      Start Qty: 1.00      **\*1\***      Cust Item ID:  
Required Date: 05/01/2012      Req'd Qty: 1.00      **\*1\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								

100

0.00

**\*100\***

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: 468

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*77882\***

Page 2

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_      **Run**      **Start**      **\*NR1\***  
                  **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_      **Stop**      **\*NR2\***

[illegible]

PH-12-23  
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

December-22-11 10:10:08 AM

Page 1

Work Order ID: 77882

\*77882\*

Parent Item: D4148-041

\*D4148-041\*

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21043-3

Purchased

No

100

Each

1,475.000

4

2

\*MS21043-3\*

Nut

\*\*

### Location

### Loc Qty

### Loc Code

FG

72

103691

72

ST300

750

119901

750

ST301

653

118077

2

118614

445

118686

30

119758

176

MS21043-4

Purchased

No

100

Each

1,278.000

1

3

\*MS21043-4\*

Nut

\*\*

### Location

### Loc Qty

### Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

768

119309

269

119546

499

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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December-22-11 10:10:09 AM

Page 2

Work Order ID: 77882

**\*77882\***

Parent Item: D4148-041

**\*D4148-041\***

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2690-6 Manufactured No

100 Each 6.0000 1 1

**\*D2690-6\***

Lanyard Assembly

\*\*

Location

Loc Qty

Loc Code

ST020

6

74515

6

D3910-1 Manufactured No

100 Each 9.0000 1 1

**\*D3910-1\***

Crosstube Lug

\*\*

Location

Loc Qty

Loc Code

st507

9

73527

9

D4091-1 Manufactured No

100 Each 24.0000 1 1

**\*D4091-1\***

Mounting Lug

\*\*

Location

Loc Qty

Loc Code

ST458

20

77320

20

ST460

4

69605

4

D4148-1 Manufactured No

100 Each 4.0000 2 2

**\*D4148-1\***

Crosstube Lug Plate, Fwd

\*\*

Location

Loc Qty

Loc Code

ST133

4

70161

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

December-22-11 10:10:09 AM

Page 3

Work Order ID: 77882

**\*77882\***

Parent Item: D4148-041

**\*D4148-041\***

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4148-3 Manufactured No

100 Each 1.0000 1 1

**\*D4148-3\***

Stud Receiver, Lower

\*\*

Location

Loc Qty

Loc Code

ST133

1

70856

1

D4148-5 Manufactured No

100 Each 6.0000 1 1

**\*D4148-5\***

Eyebolt Stud

\*\*

Location

Loc Qty

Loc Code

ST133

6

71932

6

AN3C12A Purchased No

100 Each 66.0000 2 2

**\*AN3C12A\***

Bolts

\*\*

Location

Loc Qty

Loc Code

ST351

66

117514

4

118112

5

118422

17

118451

22

119510

18

AN4C13A Purchased No

100 Each 18.0000 3 3

**\*AN4C13A\***

BOLT

\*\*

Location

Loc Qty

Loc Code

ST357

18

118838

18

December-22-11 10:10:09 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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December-22-11 10:10:09 AM

Page 4

Work Order ID: 77882

**\*77882\***

Parent Item: D4148-041

**\*D4148-041\***

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

Purchased

No

100

Each

9.0000

1

1

**\*MS17984-C413\***

PIN, QUICK RELEASE

\*\*

*GP 11/12/22*

Location

Loc Qty

Loc Code

ST315

9

114340

1

118612

2

119623

6

1

MS20615-4M18

Purchased

No

100

Each

436.0000

8

8

**\*MS20615-4M18\***

Rivet

\*\*

*GP 11/12/22*

Location

Loc Qty

Loc Code

ST323

436

118077

251

118543

185

8

NAS1149C0332R

Purchased

No

100

Each

4,449.000

4

4

**\*NAS1149C0332R\***

Washer

\*\*

*GP 11/12/22*

Location

Loc Qty

Loc Code

ST297

4449

118354

709

119124

12

119736

3728

4

NAS1149C0432R

Purchased

No

100

Each

3,786.000

6

6

**\*NAS1149C0432R\***

Washer

\*\*

*GP 11/12/22*

Location

Loc Qty

Loc Code

ST297

3786

117291

2786

119124

1000

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

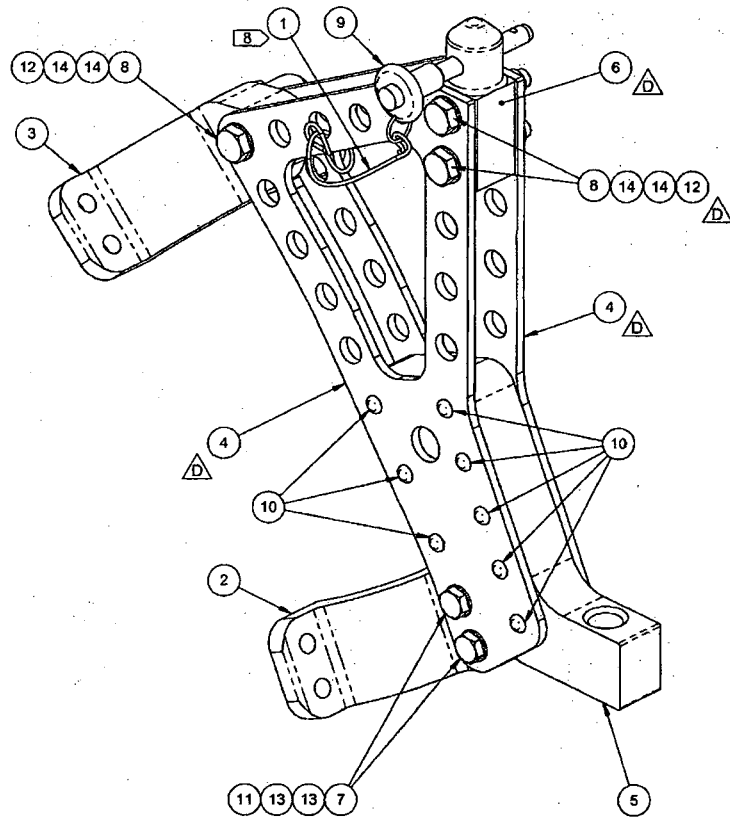
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4148-041 FWD X-TUBE LUG ASSY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
  - 7) WEIGHT: 3.67 lbs
  - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 77882 M.L.J  
11/12/22

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

**RELEASED**  
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.260" (C8-3); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS Ø.129 (ZN C8-3). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. D D4148 SHEET 1 OF 5
TITLE <b>FWD X-TUBE LUG ASSY</b>	
SCALE NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

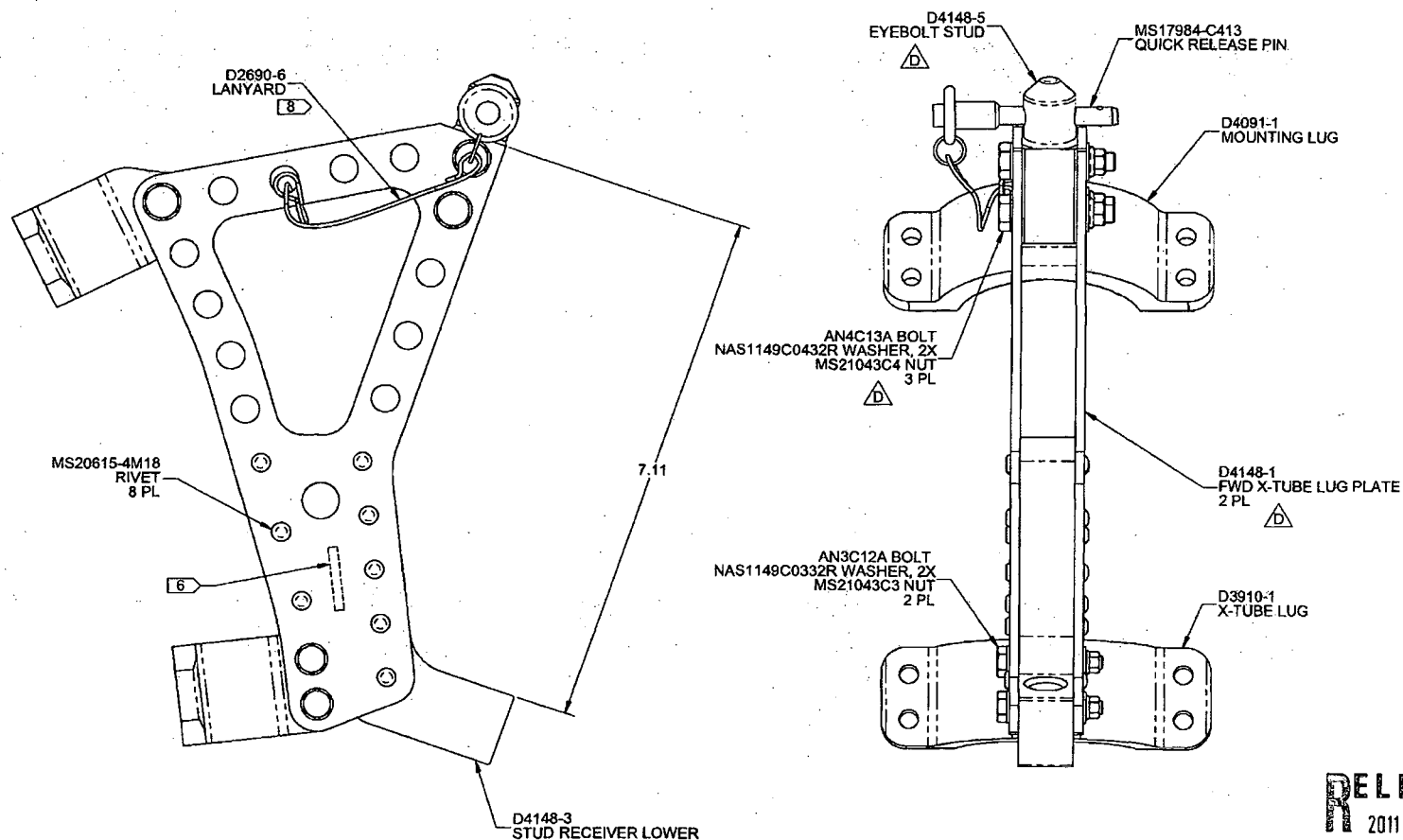
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77882

**D4148-041 FWD X-TUBE LUG ASSY**RELEASED  
2011-02-22

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

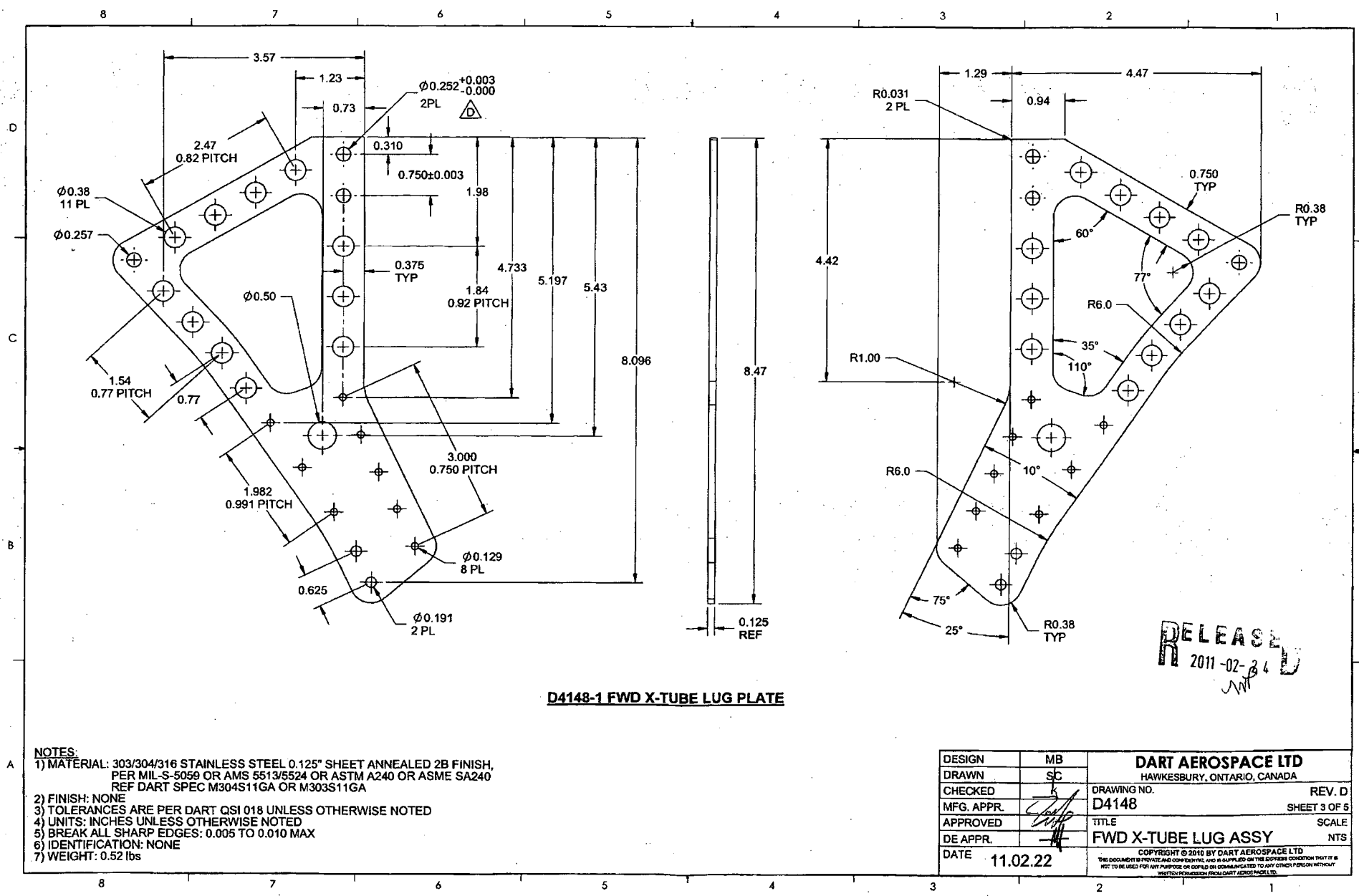
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries






77802



**D4148-1 FWD X-TUBE LUG PLATE**

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.52 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASE  
2011-02-24  
JNT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

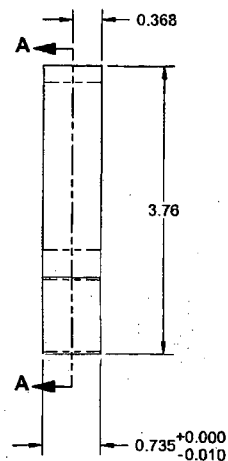
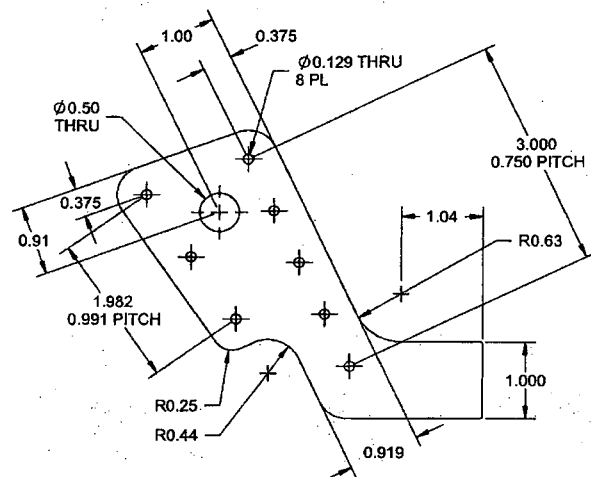
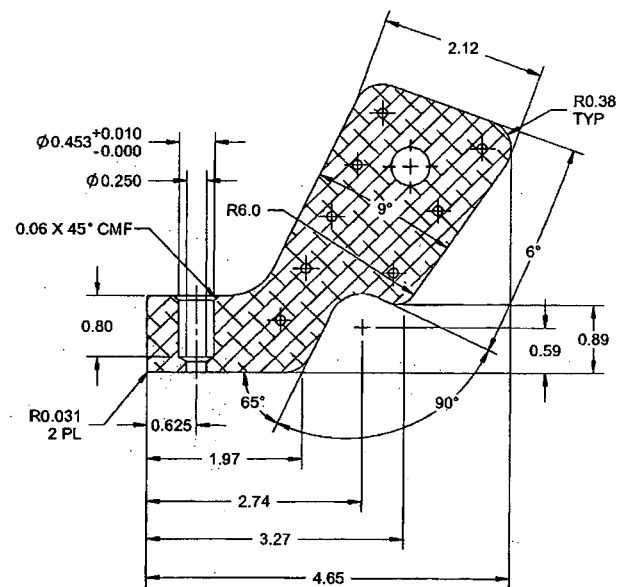
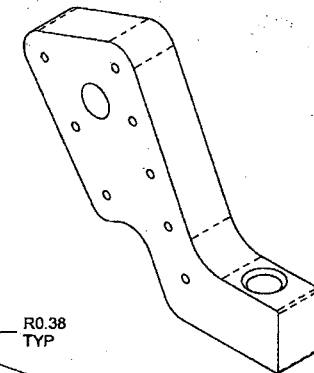
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**NOTE:** Date & initial all entries

77882

**D4148-3 STUD RECEIVER LOWER****SECTION A-A**

**RELEASED**  
2011-02-24

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4148</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>FWD X-TUBE LUG ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

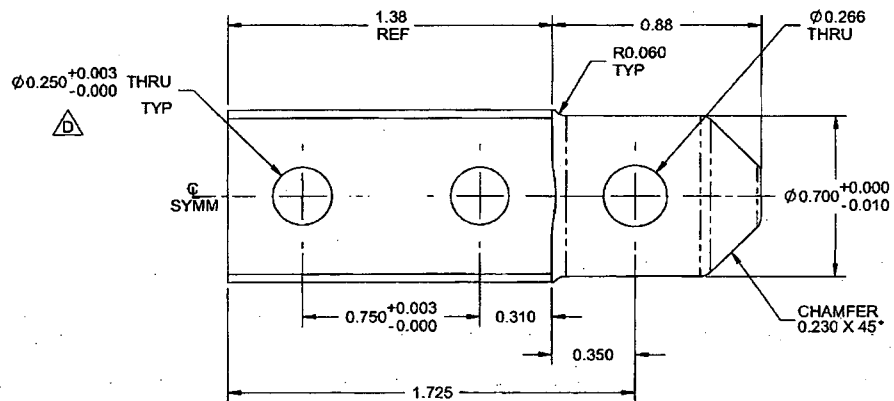
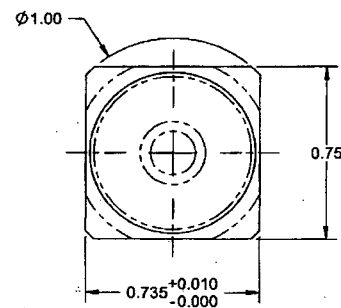
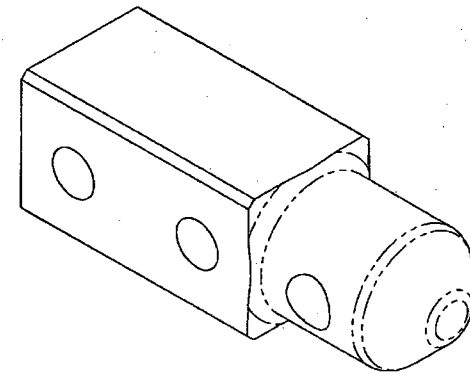
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77882



**D4148-5 EYEBOLT STUD**

RELEASED  
2011-02-24

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.		<b>D4148</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>FWD X-TUBE LUG ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries